

DART AEROSPACE LTD	Work Order:	21920
Description: Bracket	Part Number:	D3304-5
Dwg: D3304 Rev. A	Qty:	10
Ref:		Page 1 of 1

Step	Location	Procedure	By₄	Date	Qty
1	DC	Issue Traveler	#	04.11.18	10
2	PG	Issue P/O: WWW Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3304 Formed Possible Supplier: GFI & Industrial Laser Material release note is required	u	041118	10
3	RG	Receive and Inspect for transit damage Enure material release note is attached	c.L.	95/bi/o5	1)
4	QC6	Inspect dimensions as per Dwg D3304	9	05.02.02	10
5	GA	Deburr	SB	05/03/09	10
6	GB	Form as per Dwg D3304		4	
7	GA	Tumble NAAC			÷
8	QC5	Inspect work to Step#5	2	05.04.05	10
9	ST	Identify and Stock	2	65.04.05	10
10	AC	Cost / part 8, 21 Close W/O 8, 21	Suc	05.04.06	10
11	DC	Close W/O 8, Z / Inspect Level 21	KA	06.04.12	10

Rev	Date	Change	Revised By	Approy∉d
Α	04.09.07	New issue	KJ/JLM (dell
			 	



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	5						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector		
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WORK ORDER NON-CONFORMANCE (NCR)						R)			
\	Description of NC		Corrective Action Section B	Varification	Approval Design Mgr				
STEP	Section A	Initial Action Description Design Mgr Design Mgr		Sign & Date		Section C	Approval QC Inspector		
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	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Section A Initial Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Section C Design Mgr		

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	 ٠ <u>ٺ</u>
NOTE: Date & initial all entries				QA: I	V/C C	losed:	Date:	 - ,

04.08.18 NEW ISSUE	04.08.18	Α
TUBE ASSEMBLY 1:6		04.08.18
TITLE		DATE
D3304 SHEET 1 OF 4	4	#
DRAWING NO. REV. A	APPROVED.	CHECKED
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY	DESIGN RF

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. \	D3304-1	_/\frac{1}{2} \ \frac{1}{2}		D3304-3	4/1
		NO NO NO	SHO ENG CONI	<u>4-044 TUBE ASSEN</u> D3304-043 OP	
D3304	-041 TUBE ASSEMBLY	D. R. dur	TO A SINGER OF TO A S	4-044 TUBE ASSEM D3304-043 OP	IBLY (SHOWN) POSITÉ
		WORK ORDER NO. 2192	SHOW COPY RETURN TO ENGINEERING ONTROLLED		
·		WORK ORDER NO. 21920	SHOW COPY RETURN TO RETURN TO ENGINEERING ONCONTROLLED COPY		
D-7	3304-041/-043/-044		7 ~		04.00

<u>D3304-041/-043/-044 NOTES:</u>
1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3

WELD PER DART QSI 004

SIHI

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ANY PURPOSE

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COPIED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

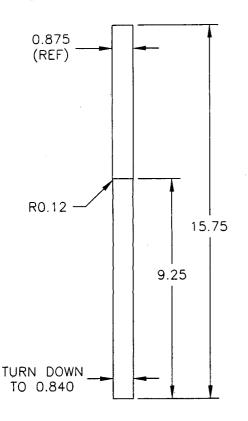
ALL DIMENSIONS ARE IN INCHES

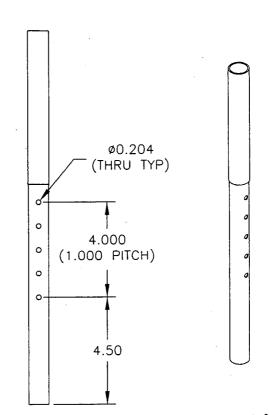
- BREAK ALL SHARP EDGES 0.005 TO 0.015
- IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "ŤCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"



DESIGN	DRAWN BY	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. A
1	1-4	D3304	SHEET 2 OF 4
DATE		TITLE	SCALE
04.08.18		TUBE ASSEMBLY	1:4

RELEASED





SHOP COPY

RETURN TO ENGINEERING

UNCONTROLLED COPY SUBJECT TO AWENDMENT WITHOUT NOTICE

WORK ORDER

NO. 21930

D3304-1 TUBE

D3304-1 NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL

(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

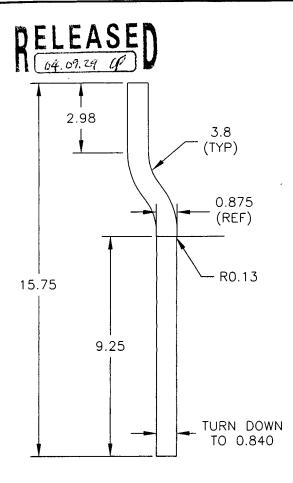
4) BREAK ALL SHARP EDGES 0.005 TO 0.015

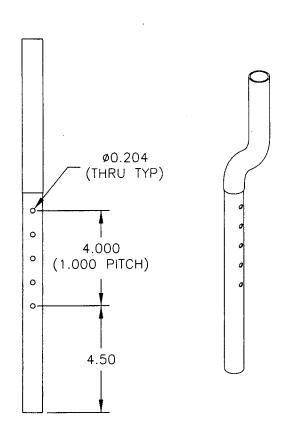
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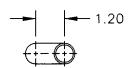
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DESIGN RF	DRAWN BY RF	DART AEROS HAWKESBURY, ON	
CHECKED ,	APPROVED	DRAWING NO.	REV. A
#	#	D3304	SHEET 3 OF 4
DATE		TITLE	SCALE
04.08.18		TUBE ASSEMBLY	1:4







SHOP COPY **RETURN TO ENGINEERING** UNCONTROLLED COPY SUBJECT TO AMENDMENT

EDITOR TUOHTIW WORK ORDER NO. 21920

D3304-3 TUBE

D3304-3 NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.875 x 0.065 WALL (REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

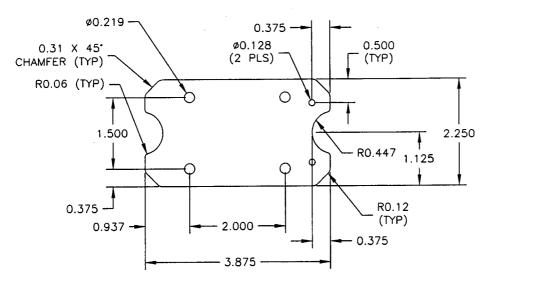
3) ALL DIMENSIONS ARE IN INCHES

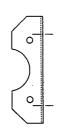
4) BREAK ALL SHARP EDGES 0.005 TO 0.015

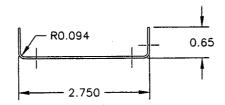


DESIGN RF	DRAWN BY RF	DART AEROS HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO.	REV. A
4	 	D3304	SHEET 4 OF 4
DATE		TITLE	SCALE
04.08.18		TUBE ASSEMBLY	1:2

RELEASE 04.09.29







D3304-5 BRACKET

SHOP COPY

RETURN TO **ENGINEERING**

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SUBJECT TO ALIENE ENT

WITHOUT NOTICE

WORK ORDER NO. 21920

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Nov 17, 2004

07:47 am

Work Order No : 0021920 : D3304-5 Project Name

Project For : WK450

: Main Work Order Type

Main WO Number

House Part Number: D3304-5 Description : Bracket

Manufactured : Yes

Amount Req'd: 10
Amount Done: 0
Start Date: 11-16-04

Start Date Est Finish Date : 12-04-04

Act Finish Date :

Drawings Reqd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number:

Invoice Amount: 0.00

Order Entry No :

OE Value : 0.00

Est Margin : 0.000% Actual Margin : 0.000%

\$0 Posted to Finished Goods

		Estimated	Actual	٧ar. %	Posted	To Post
=======================================	==:		=========	=======	==========	=======================================
Material Cost	:	0.00	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00		
Engineering Cost	:	0.00	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00		
Production Cost	:	0.00	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00		
Packaging Cost	:	0.00	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00		
OverHead Cost	:	0.00	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00		
CNC	:	0.00	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00		
Misc.	:	0.00	0.00	0.00	0.00	0.00
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Total Cost	:	0.00	0.00	0.00		
Margin	:	0.000	0.000			•
Selling Cost	:	0.00	0.00			

Estimated Actual Labour Hrs/Amount Done : 0.00 0.00 Profits/(Loss) 0.00 0.00

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序号 Item N	捆包号 Case No. (Crate No.)	冷卷号 Coil No.	炉号 Heat No. 175097 220107		规格尺寸 Size(mm) 20GA*48INCHES*C 20GA*48INCHES*C		数量 Quantity	重量 Mass (kg) 5745 5010	c	Certifica	Mn		Chemic	型 Date	行 日 sition in		2002/09/26		
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